

Work Order ID 85969

85969

Page 1

June-19-12 11:58:13 AM

Item ID: D2353

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Stiffener

Stop

NS2

Start Date: 19/06/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/19

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2353	Rev C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2353 Dwg Rev: C Prog Rev: C 2-
Deburr if necessary

2024 050

10 0 Jm 12-6-23

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

10 0 Jm 12-6-23

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

10 0 12 06 24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Revision ID:

Stop ***NS2***

Item Name: Stiffener

Start Date: 19/06/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

130

NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

Bend per Dwg D2353

140

140

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

150

150

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

SB
12/06/25

W/O 06 25

Pro

9 NG 12-6-26

W/O: 85969

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2353 PAR #: _____ Fault Category: Scrap NCR: Yes No DQA: Not Date: 12/07/10
 Resolution: _____ Disposition: Scrap QA: N/C Closed: ck Date: 12/7/10

NCR: 12-1565

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
120625	130	1 cracked during bending. Found during inspection material	<u>W</u> 120625	Scrap + Destroy	<u>SB</u> 120625	<u>m/h</u> 120625	<u>W</u> 120625	<u>m</u> 120625

NOTE: Date & initial all entries

Work Order ID 85969

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Item ID: D2353

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Stiffener

Start Date: 19/06/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
155	QC7-Inspect Chemical Conversion Coat	0.00							
155									
QC	Memo	0.00							
Quality Control									
160	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
160									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 8-15								
	FINISH TIME: 3200 F								
	OVEN TEMPERATURE: 8-45								
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									

9 0 1273

9X 0 12/07/03

9 0 1273

W121279

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

85969

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 19/06/2012 **Start Qty:** 10.00 ***10***

Cust Item ID:

Required Date: 03/07/2012 **Req'd Qty:** 10.00 ***10***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180 Identify as per dwg & Stock Location: ST 225 0.00

180

Packaging

Packaging

Memo

0.00

190	QC21- Final Inspection - Work Order Release	0.00
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190

QC

Quality Control

Memo

0.00

94

sp
12-7-3

12/7/4

mc

12-08-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-19-12 11:58:16 AM

Page 1

Work Order ID: 85969

85969

Parent Item: D2353

D2353

Parent Item Name: Stiffener

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev: A Removed from 9 Digit 05-11-10 EC
 IPP: B 06.11.15 waterjet EC
 IPP: c 06.12.07 ecn 836 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	255.0500	0.1463	1.54			

M2024T3S 050

2024-T3 .050 sheet

**

Jm 12-6-23

Location

Loc Qty

Loc Code

MAT022

255.05

117684

22.8

121216

90.75

121889

141.5

121216

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

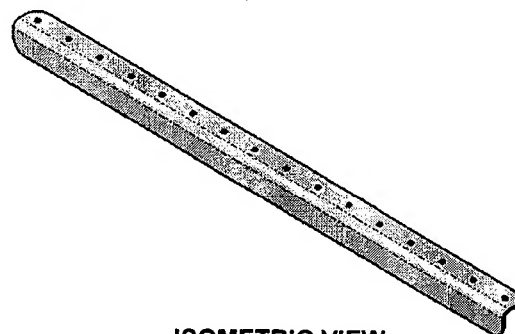
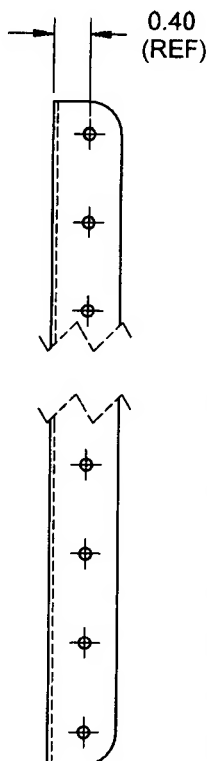
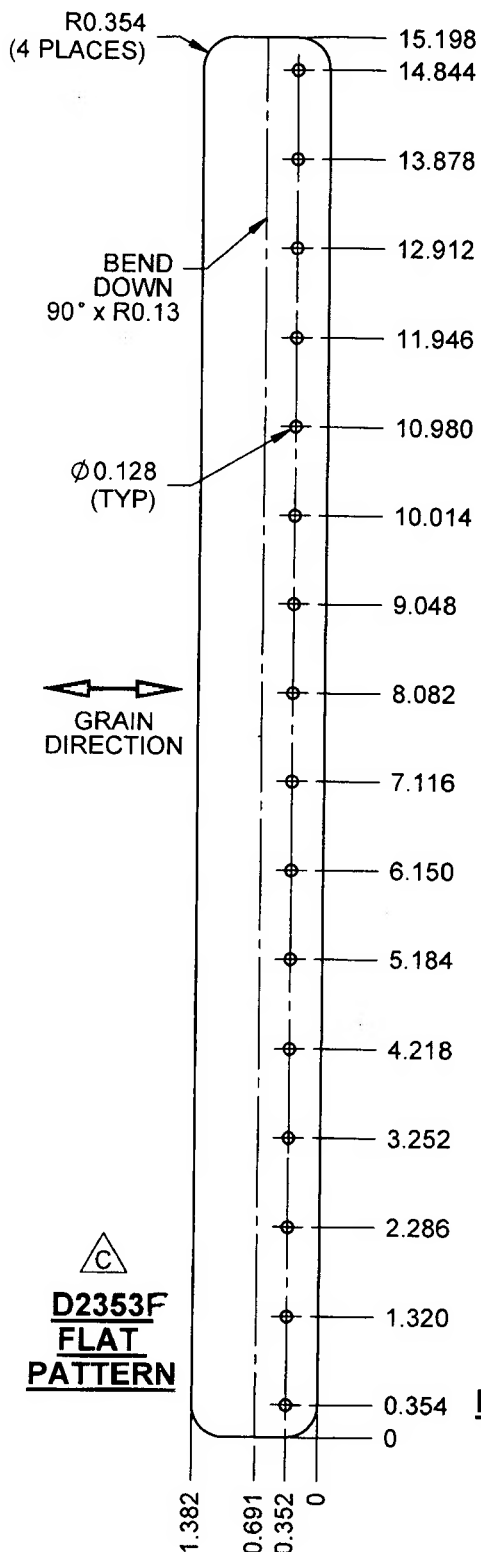
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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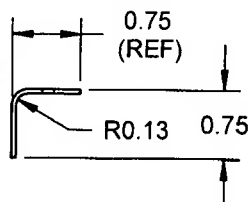
NOTE: Date & initial all entries



DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D2353	REV. C SHEET 1 OF 1
DATE 06.11.13	TITLE STIFFENER	SCALE 1:2	
REV	DATE	DESCRIPTION	
B	95.02.23	ADD TEXT	
C	06.11.13	ADD FLAT PATTERN; ADD NOTES; UPDATE DWG	



- NOTES:
- 1) MATERIAL: ALUMINUM 2024-T3 SHEET, 0.050 THICK
PER QQ-A-250/4 OR AMS 4037
(REF DART SPEC M2024T4S.050)
 - 2) FINISH: CHEMICAL CONVERSION COAT
PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7)
PER DART QSI 005 4.3
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) IDENTIFY WITH DART P/N "D2353" USING A WHITE FINE POINT PERMANENT INK MARKER
 - 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



**D2353
BEND DETAIL**

NO. 85769 MCJ
12/06/19
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

RELEASED

06-11-28 [Signature]

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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